

# Work Order ID 65118

January 6, 2011 1:51:21 PM



Page 1

Item ID: D2519

Accept



Setup Start



Revision ID:

Stop



Item Name: Clamp

Start Date: 1/06/11 Start Qty: 50.00



Cust Item ID:

Required Date: 1/21/11 Req'd Qty: 50.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 11/01/06 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2519	Rev D								

100 0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 13234 ☐ Laser cut as per Dwg D2519 ☐ Material release note required

GFI

CL 11/01/06 50

110 0.00



Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

CL 11/01/24 50

120 0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

(8.561" center to center)

8/11/11/11

CL 11/01/11 50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 65118

January 6, 2011 1:51:21 PM



Page 2

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Setup Start



Revision ID:

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Item Name: Clamp

Start Date: 1/06/11

Start Qty: 50.00



Cust Item ID:

Required Date: 1/21/11

Req'd Qty: 50.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Small Fab

Small Fab

Memo

0.00

0.00

Small Fab

1-Deburr any rough edges □2-Bend as per Dwg D2519□3- tumble

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

150



Packaging

Packaging

Identify as per dwg & Stock Location: 462

Memo

0.00

0.00

N/A u

Ref-1/27 (50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 65118**

January 6, 2011 1:51:21 PM



Page 3

Item ID: D2519

Accept



Setup Start



Revision ID:

Stop



Item Name: Clamp

Start Date: 1/06/11 Start Qty: 50.00



Cust Item ID:

Required Date: 1/21/11 Req'd Qty: 50.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/27  
50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

January 6, 2011 1:51:20 PM

Page 1

Work Order ID: 65118



Parent Item: D2519

Parent Item Name: Clamp



Start Date: 1/06/11

Required Date: 1/21/11

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP: B□00.03.16□Re-format, laser cutting□EC□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2519F  Clamp		Purchased	No			120	Each	0.0000	1	50			
65118												C2 11/01/24	50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

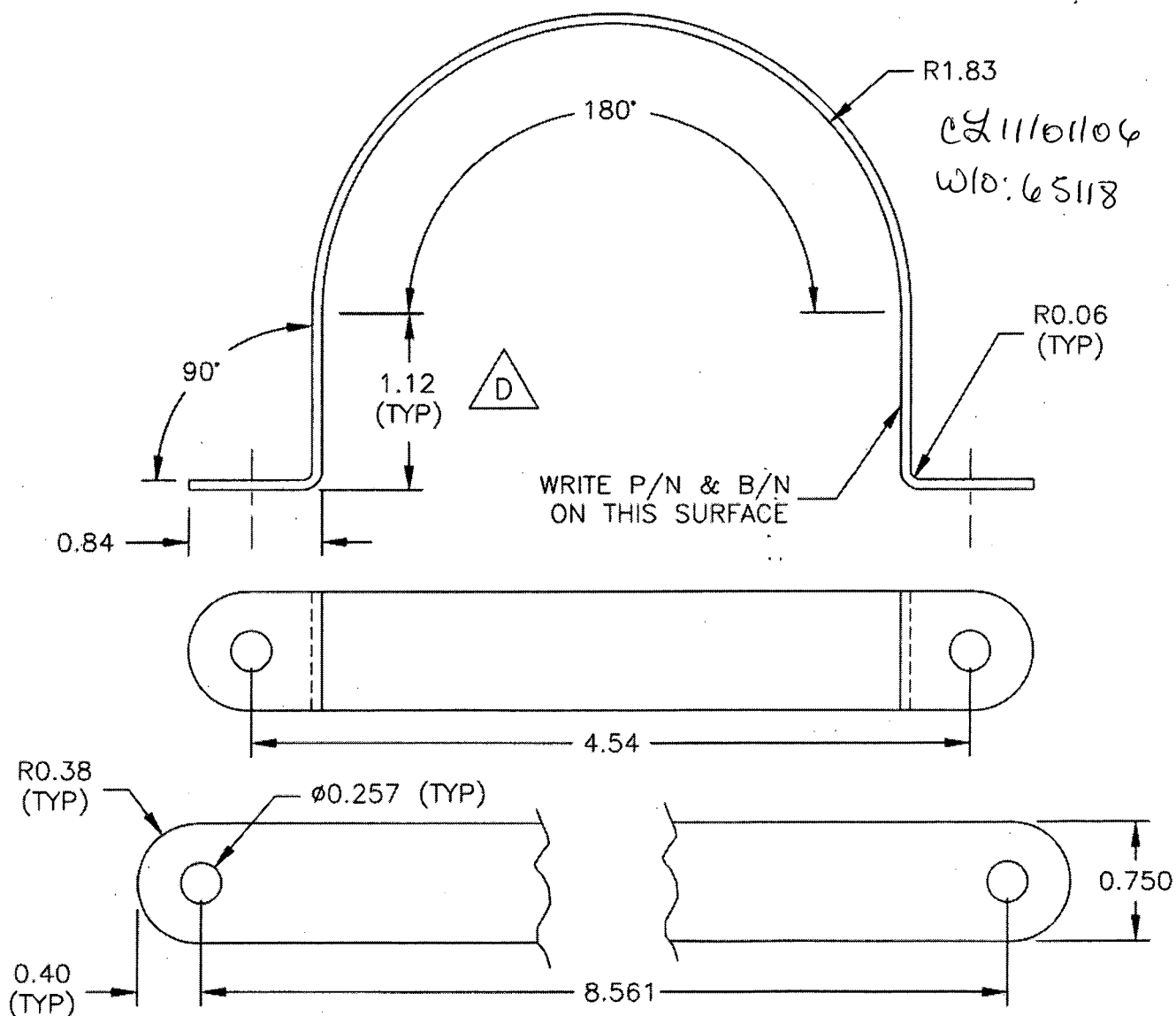
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2519	REV. D SHEET 1 OF 1
DATE 04.11.08		TITLE CLAMP	SCALE 1:1
A	95.11.28	NEW ISSUE	
B	97.03.24	ADD MATERIAL SPECIFICATION	
C	00.02.29	REDRAWN; ADDED FLAT PATTERN	
D	04.11.08	1.12 WAS 0.93	

**RELEASED**  
04.11.26 *[Signature]***D2519 FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.063 (16 GAUGE) THICK, (REF. DART SPEC. M304S16GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSION ARE IN INCHES
- 4) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER ON SURFACE SHOWN

# SPECIFICATION CONTROL DRAWING

PURCHASE MATERIAL: AISI 304/316 SS SHEET  
ANNEALED  
2B FINISH

SPECIFICATION: MIL-S-5059  
OR AMS 5513 (304)  
OR AMS 5524 (316)  
OR ASTM A240  
OR ASME SA240

PART NUMBER: M304S TT GA  
GA

WHERE "TT" = GAUGE THICKNESS

EG. 16 GAUGE SS SHEET = M304S16GA

GAUGE THICKNESS REFERENCE:

GAUGE	NOM. THICK. (IN)	THICKNESS RANGE (IN)
26	0.01875	0.0178 - 0.019
25	0.021875	0.0199 - 0.023
24	0.025	0.024 - 0.026
23	0.028125	0.027 - 0.029
22	0.03125	0.030 - 0.032
21	0.034375	0.033 - 0.035
20	0.0375	0.036 - 0.040
19	0.04375	0.041 - 0.046
18	0.050	0.047 - 0.052
17	0.05625	0.053 - 0.058
16	0.0625	0.059 - 0.065
15	0.0703125	0.066 - 0.072
14	0.078125	0.073 - 0.083
13	0.09375	0.084 - 0.098
12	0.109375	0.099 - 0.114
11	0.125	0.115 - 0.130
10	0.140625	0.131 - 0.145
9	0.15625	0.146 - 0.160
8	0.171875	0.161 - 0.176

REFERENCE ONLY

RELEASED  
09/06/01

B	REFORMAT DWG, ADD ASTM/ASME SPECS (ZN D8-1), ADD GAUGE REF (C8-1), REF PAR 08-020A	CP	09.06.01
A	NEW ISSUE	DS	01.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.06.01		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. M304S	REV. B SHEET 1 OF 1
TITLE 304/316 SS SHEET	SCALE NTS
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Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO13234

Purchase Order Date 1/06/11

PO Print Date 1/06/11

Page Number 1 of 1

Order From :

VC-GFI001

GFI  
180 AVENUE LABROSSE  
POINTE CLAIRE, QC H9R 1A1  
CA

Contact Name

Vendor Phone 514 630 4877

Vendor Fax 514 630 4849

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**FAXED**  
e-mail Radio

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2519F CL11101124	Clamp	1/11/11 Yes	50.00 Each	Yours ppd	\$10.8000	\$540.00

Special Inst: AS PER DWG D2519 REV. D  
B65188

PO Total:

\$540.00

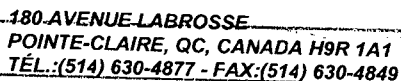
CERTIFICATE OF CONFORMITY  
REQ'D UPON DELIVERY

MATERIAL CERTIFICATION  
REQ'D UPON DELIVERY

Change Nbr: 1

Change Date: 1/06/11

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable



GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.



DATE DE LIVRAISON/SHIPPING DATE			N° DE BON DE LIVRAISON SHIPPING MEMO NO.	PAGE
NR-DY	MO-MO	AN-YR		
20	01	11	0454245	1/1

VENDU À / SOLD TO


EXPÉDIÉ À / SHIP TO

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON  
K6A 1K7

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON  
K6A 1K7



CODE DE CLIENT CUSTOMER CODE		N° DE CONTRAT JOB NO	VOTRE N° DE COMMANDE YOUR PURCHASE ORDER NO.	EXPÉDIÉ PAR SHIP VIA
DART	GFI-0299	0225688	PO13234	

QUANTITE QUANTITY	N° DE PIÈCE PART NO	DESCRIPTION
50	D2519F ✓ C211101124  MFG. JOB# J0225688-001 QTY 50  	CLAMP

REÇU PAR / RECEIVED BY

DATE \_\_\_\_\_

EXPÉDITEUR  
SHIPPER

N° DE BON DE LIVRAISON  
SHIPPING MEMO NO.



TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION.  
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

CERTIFICATE OF COMPLIANCE  
CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas&Betts**

180 LABROSSE AVENUE  
POINTE CLAIRE, QC  
H9R 1A1

**DART AEROSPACE LTD**  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7

8 w/ 127

CERTIFICATE NO. 9 OUR JOB NO J0225688 SHIPPING MEMO 0454245

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
<u>50 PCS</u>	<u>PO13234</u>	<u>D2519F</u>	<u>D</u>	<u>CLAMP</u>	<u>D</u>	
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
<u>.062 THK S.S.T 304</u>		<u>SAMUEL / AK STEEL</u>		<u>7400337 ATT'D</u>		

	PROCESS	PROCESSOR	RELEASE NOTE #
1	REF. GFI MANUFACTURING JOB NUMBER J0225688-001 (50 PCS)		
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 20 JANUARY 2011

G.F.I. Q.C. REP. *Robert Hatt*



CL11/01124

# SAMUEL

SAMUEL & FILS & CIE (QUEBEC) LTEE.,  
2225 AVE. FRANCIS HUGHES,  
CHOMEDEY, LAVAL  
QUEBEC, H7S 1N5  
(514) 384-5220 FAX (450) 669-0633

No

001859712



TRANSPORTEUR/CARRIER NAME  
- SSMQ

CAMION/TRUCK  
495

NOM DE LA BRANCHE/SALES BRANCH NAME

SAMUEL & FILS & CIE (QUEBEC) L

PAGE 1 DE/OF 2

DATE OF SHIPMENT  
12/14/10

### VENDU À/SOLD TO:

GFI, DIVISION DE THOMAS & BETTS LTEE  
180 LABROSSE

POINTE-CLAIRE

QC

H9R1A1

(514) 630-4877

### EXPÉDIÉ À/SHIP TO: TAB: SSMQ

GFI INC.  
180 LABROSSE

POINTE-CLAIRE

QC

H9R1A1

CA

(201009-00001)

N° COMMANDE  
N° ITEM  
092078-01

### DESCRIPTION ET POIDS/DESCRIPTION AND WEIGHT

#Comm du client: CC06314  
1 PC S/S PRIME SHEET 304 #4

Cert/Test: FAX  
101 LVR

.0620"x48"x120"

#Pièce Ts0624812044

Description

#Étiq mln

Art

#À soul

Pd ca

Qté

#Étiq

Étq princ

Vendeur Org

#Coul

5792253

076

DE

46 KG

P255384 513733

9919255

Total:

1

40.000

101

46 KG

092078-02

#Comm du client: CC06314  
10 MCX FEUILLE INOXYDABLE 304 2B

Cert/Test: FAX  
806 LVR

.0620"x48"x96"

c of c & Mill test Req.

#Pièce Ts06248x9642

Description

#Étiq mln

Art

#À soul

Pd ca

Qté

#Étiq

Étq princ

Vendeur Org

#Coul

5792620

611

US

366 KG

P420582 7400337

427461-06B

Total:

10

320.000

806

366 KG

DEPT. DE  
CERTIFICATION

12/15/10

*Loiseleur*

ÉPAR

PORT PAYÉ/PREPAID

PORT DU COLLECT

INST. VOITURIER/DRIVER INSTRUCTIONS

EXPÉDITEUR/DISPATCHER

VOITURIER/DRIVER

VALEUR (\$2.00/lb max à moins d'avis contraire)  
VALUATION (Max \$ 2.00/lb unless otherwise stated)  
VALUER DÉCLARÉE DE L'EXPÉDITION  
DECLARED VALUE OF SHIPMENT  
REÇU PAR/RECEIVED BY

2. VOITURIER (CE CONNAISSEMENT DOIT ÊTRE SIGNÉ PAR L'EXPÉDITEUR ET LE VOITURIER)



AK Steel Corporation  
Metallurgical Test Report  
Rockport Works  
Rockport, IN 47635

Page 1

Load No. 9686712  
SRN No. 9686712

C  
U  
S  
T  
O  
M  
E  
R

SAMUEL & FILS & CIE LTEE (S)  
PUR DEPT  
2225 FRANCIS HUGHES DRIVE  
LAVAL, CN H7S1N-5

S  
H  
I  
P  
T  
O

SAMUEL & FILES (QUEBEC) LTEE  
2225 FRANCIS HUGHES  
LAVAL, CN H7S1N-5

MILL ORDER NO. 252502-1552  
PROCESSOR ORDER NO. C11868-3  
BUYERS ORDER NO. C11868-3

PART NO.

ENGLISH UNITS --PRODUCT-- METRIC UNITS  
.0590 NOM 48.0000 X COIL

COIL ID	PIECE	HEAT	PARENT COIL ID	NET WEIGHT	OUTSIDE PROCESSOR ID
427461-06A	1	7400337	0427461-06	20,460 LBS. 9,281 KG.	475860701
427461-06B	1	7400337	0427461-06	20,090 LBS. 9,113 KG.	475860702
TOTAL COILS	TOTAL PIECES			TOTAL NET WEIGHT	
2	2			40,550 LBS. 18,394 KG.	

L-Ladle Analysis of Heat

P-Product Analysis of Parent Coil

CHEMICAL ANALYSIS

ID	C	MN	P	S	SI	CR	NI	MO	N	CU						
L 7400337	.024	1.243	.024	.0009	.438	18.15	8.10	.25	.0320	.25						

SHIPPING DATE: 04/29/2010

REMARKS:

NO INTENTIONAL ADDITIONS OF MERCURY OR MERCURY COMPOUNDS WERE  
MADE OR USED THROUGHOUT THE PROCESSING AND TESTING OF THIS MATERIAL  
MATERIAL FREE OF RADIOACTIVE ISOTOPES  
MELTED & MFG IN THE USA

PRODUCT DESCRIPTION

CR SHT TYPE 304/304L STAINLESS #2B FINISH SLIT EDGE \* ASTM A 240 -09C \* ASTM A 480 -09 EX PARA 25.1.1.3 COIL WILL BE TAGGED ON  
OUTSIDE ONLY \* ASME SA-240 SECTION II PART A (2004 ED, 2005 ADDENDA) \* ASME SA-480 SECTION II PART A (2004 ED, 2005 ADDENDA) \* A  
STM A 262 -02A (2008) PRACTICE E \* ASTM A 566 -03 EX 7.1 TEST SPECIMENS WILL BE SELECTED IN THE TRANSVERSE TEST DIRECTION IN ALL  
CASES.

PARENT COIL ID	POS (F/T)	DIR (L, T, D)	COND	% ELONG	ELONG METHOD	ELONG GAUGE LENGTH	TENSILE STRENGTH (KSI)	Y.S. 1% OFFSET (KSI)	ROCKWELL HARDNESS Tall	ROCKWELL HARDNESS Front
0427461-06	T	T	A.S.T.M	51.1	MEASURED	2 Inch	95.8	47.8	BW 89	BW 88

\*\*\* CONTINUED ON NEXT PAGE \*\*\*



**AK Steel Corporation**  
**Metallurgical Test Report**  
**Rockport Works**  
**Rockport, IN 47635**

Page 2

Load No. 9686712  
SRN No. 9686712

C  
U  
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SAMUEL & FILS & CIE LTEE (S)  
PUR DEPT  
2225 FRANCIS HUGHES DRIVE  
LAVAL, CN H7S1N-5

S  
H  
I  
P  
T  
O

SAMUEL & FILES (QUEBEC) LTEE  
2225 FRANCIS HUGHES  
LAVAL, CN H7S1N-5

MILL ORDER NO.  
252502-1552

PROCESSOR ORDER NO.  
C11868-3

BUYERS ORDER NO.  
C11868-3

PART NO.

ENGLISH UNITS --PRODUCT-- METRIC UNITS  
.0590 NOM 48.0000 X COIL

PARENT COIL ID	POS (F/T)	DIR (L, T, D)	COND	ASTM A 262 PRACTICE E	BEND 180 1T						
0427461-06	T		A.S.T.M	PASS	PASS						

THE CHEMICAL ANALYSIS AND PHYSICAL OR MECHANICAL TESTS REPORTED ABOVE ARE CORRECT  
AS CONTAINED IN THE RECORDS OF THE CORPORATION.

ALL TESTING IS DONE IN ACCORDANCE WITH A.S.T.M STANDARDS UNLESS OTHERWISE NOTED

AK Steel Corporation

MWQC#0049 S/99

"THIS CERTIFIED TEST REPORT HAS BEEN DELIVERED TO A CONSIGNEE OF MATERIAL PURCHASED FROM AK  
Steel Corporation. TO AVOID THE POSSIBILITY OF ITS MISUSE ON DELIVERY OF THE REPORT TO A  
THIRD PARTY IT MUST BE RECERTIFIED BY AND UNDER THE NAME OF SUCH CONSIGNEE"

SIGNED

*R.A. West*  
R. A. WEST QUALITY MANAGER

DATE 04/29/2010 TIME 07:32 AM